

Date: Monday, 1/16/2006 4:23:09 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b> :	25513		
<b>Estimate Number</b> :	10268		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D350636014
<b>This Issue</b> :	1/16/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2750 REV C1
<b>First Issue</b> :	1/16/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	25512	<b>Drawing Revision</b> :	C1
	<b>Type</b> :	<b>Material</b> :	N/A
	LANDING GEAR	<b>Due Date</b> :	2/10/2006
<b>Written By</b> :	SEE COMMENT BELOW		
<b>Checked &amp; Approved By</b> :	SEE ABOVE USER & DATE		
<b>Comment</b> :	Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:H 05.12.08 Rearranged procedure steps EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 001

①  
 DT 06/02/24

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B25384 Pm 06-02-02 ①

3.0	D2744	Fwd Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2744

Cap

B23098 BE 06-02-06 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

Pm 06-02-02 ①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330

Pm 06-02-02 ①

\*\*\*\*\*Drill last hole using Dt 8820 locating off last hole drilled\*\*\*\*\*

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size

Pm 06-02-02 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:23:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-4),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides.

*pmc 06-02-02 ①*

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330  
\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

*pmc 06-02-02 ①*

6-Open holes to .500" as per detail "B&C".

*pmc 06-02-02 ①*

7-Open holes to .375"mas per detail "D"

*pmc 06-02-02 ①*

8-Cut fwd end of tube as per Dwg D2750

*pmc 06-02-02 ①*

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

*pmc 06-02-02 ①*

10-Open holes to .391" as per detail "D"

*pmc 06-02-02 ①*

11-Deburr

*pmc 06-02-02 ①*

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod

*MP100 BE 06-02-06 ①*

13-Grind welds flush as per Dwg D2750

*BE 06-02-06 ①*

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 06-02-08*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*pmc 06-02-08 ①*

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

*B25540*

*pmc 06-02-08 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D2743

Crossbolt spacer

*B24641 BE 06-02-10 (1)*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *PM 06-02-08 (1)*

2-Deburr and blow out all chips from inside of tube *PM 06-02-08 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

*M19597*

Sikaflex expire date: *06-06-18*

*PM 06-02-08 (1)*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

*M19100 BE 06-02-10 (1)*

5-Grind welds flush as per Dwg D2750

*AT 06-02-10 (1)*

6-Spot face ground handling holes AE0.750" (8 places)

*AT 06-02-13 (1) BE 06-02-13 (1)*

7-Deburr holes

*AT 06-02-13 (1)*

*BE 06-02-13 (1)*

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

*PD 06-02-15*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*A.M. 06-02-22 (1)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*FC 06 02 22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D27422	Blade Fitting, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, RH	246410

FC

14.0	AN835A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

FC

15.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

FC

16.0	MS21083N8	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185

FC

17.0	D26483	Wearpad
------	--------	---------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	239784

FC

18.0	D265613	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	524147

FC 06 02 22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B24148

FC

20.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B24149

FC

21.0

ALS41032225

Insert



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 (or AKS4-1032-225) (or ALS7-1032-225) (or AKS7-1032-225)	Insert	A41576

FC

22.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M9185

FC

23.0

AN35A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M141526

FC

06 02 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001, Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m19185

FC

25.0	D2745	Bushing
------	-------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	h241146

FC

26.0	AN644A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	m18949

FC

27.0	MS21042L6	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	m176141

FC

28.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	m19185

FC 060222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:23:10 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
4	AN960JD10	Washer

Batch  
m16066

FC 060222

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291

Sikaflex expire date: 06 18 06

m19597

FC

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291

Sikaflex expire date: 06 18 06

m19597

FC 060222

3-Install D2745 Bushing as per Dwg. D2750 Detail M

FC

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

FC

31.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

32.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0	D2741	Blade
------	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty	Part Number	Description
1	D2741	Blade

Batch  
B24595B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 06/02/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:23:11 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25513

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

34.0 AN960JD816 1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 AN960JD816 Washer *M6956*

35.0 MS21083N8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 MS21083N8 Nut *M18728 1mcx M19058 1mcx*

36.0 AN816A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number Description Batch

2 AN8-16A Bolt *M 5760*

37.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C206/02/27 (1)*

38.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

*NEW D C206/02/27 (1)*

39.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*C206/02/08*

Job Completion



*U 06-02-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





RELEASED  
98.12.16 DS

DESIGN <del>DA</del>	DRAWN BY CP	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <del>DA</del>	APPROVED KE	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	CP <del>DA</del>	05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
<del>40</del>	<del>40</del>	<del>40</del>	<del>40</del>	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
<del>44</del>	<del>44</del>	<del>44</del>	<del>44</del>	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
Dec 9133 98.01.19 DS	Dec 9157 98.10.21 DS

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO  
WITH HOLT

WORK ORDER

NO. 25513



DESIGN <i>DA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DA</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

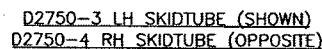
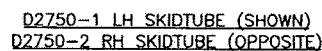
SHOP COPY  
RETURN TO  
ENGINEERING

EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 9157 99.10.21 DS

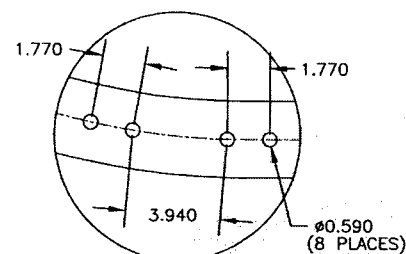
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 25513

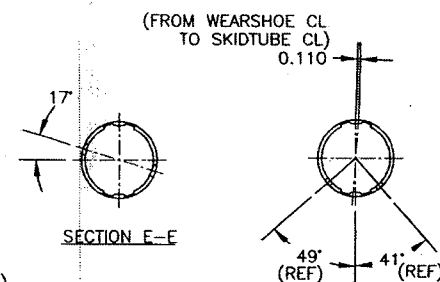
RELEASED  
99.12.16 DS



D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.




DETAIL D  
(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



SECTION F-F

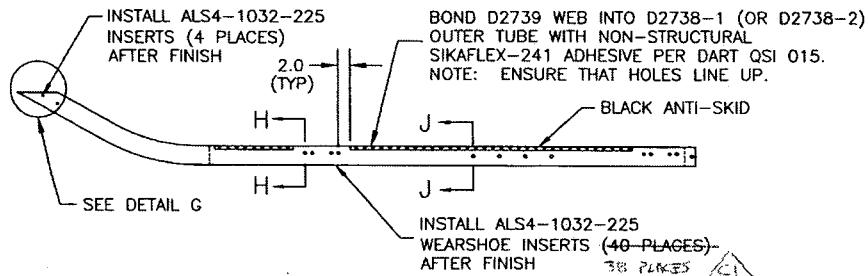
RELEASE  
98.12.16 DS

EFFECTIVE	DEOs
000 9133 98.01.19 DS	000 9157 99.01.21 DS

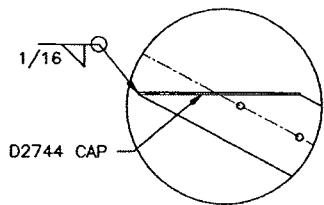
DESIGN #1	DRAWN BY CP	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED PHT	APPROVED HE	
DATE 98.11.18	DRAWING NO. D2750	REV. C SHEET 3 OF 4
	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:20

SUPPLEMENTARY COPY  
 RETURN TO  
 THE ENGINEERING  
 DEPARTMENT  
 CONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 25513

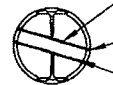
**D2750-1/-2/-3/-4 WELDING DETAIL**  
(FLOAT ATTACHMENT HOLES REMOVED)  
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



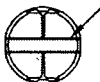
**DETAIL G**



**SECTION H-H**

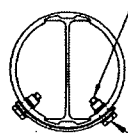


**SECTION J-J**



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2743 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. DRILL OUT SPACER TO Ø0.484
  6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

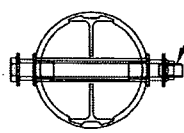
**DETAIL K**



USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD

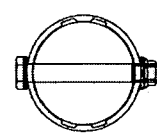
AN3-5A BOLT (1)  
AN960JD10L WASHER (1)  
(44 PLACES)  
(42 PLACES)

**DETAIL M**



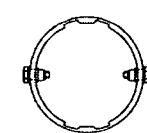
AN6-44A BOLT (1)  
D2745 BUSHING (2)  
MS21042L6 NUT (1)  
(4 PLACES)

**DETAIL P**



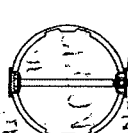
AN8-35A BOLT (1)  
AN960JD816 WASHER (2)  
MS21083N8 NUT (1)

**DETAIL Q**



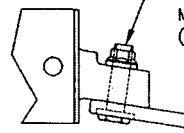
AN3-6A BOLT (1)  
AN960JD10 WASHER (1)  
(4 PLACES)

**DETAIL L**



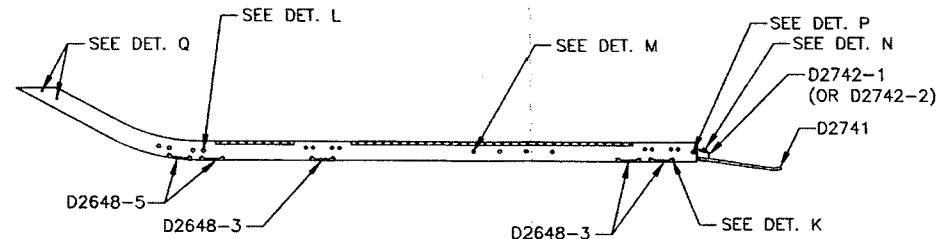
AN3-32A BOLT (1)  
A3235-020-935 PLUG (2)  
MS21042L3 NUT (1)  
(4 PLACES, FOR D2750-041/-042 ONLY)

**DETAIL N**

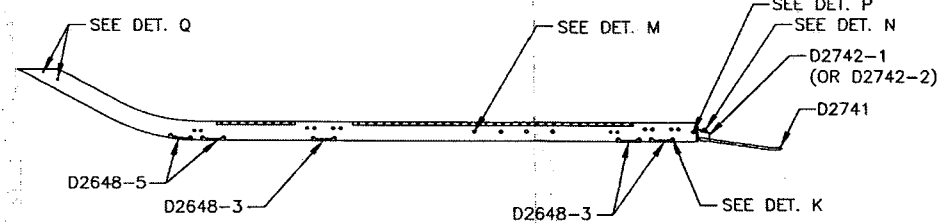


AN8-16A BOLT (1)  
AN960JD816 WASHER (1)  
MS21083N8 NUT (1)  
(2 PLACES)

**D2750-041/-042 ASSEMBLY**  
D2750-041 SHOWN (D2750-042 OPPOSITE)



**D2750-043/-044 ASSEMBLY**  
D2750-043 SHOWN (D2750-044 OPPOSITE)



**RELEASED**  
98.12.16 DS

EFFECTIVE	DEOS
100 4/33 98.01.19 DS	100 4/57 99.10.21 DS

DESIGN #1	DRAWN BY CP	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED #1	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY
		REV. C SHEET 4 OF 4 SCALE 1:20

WORK ORDER  
25513